Work Order ID 72568

Tuesday, August 02, 2011 10:03:40 AM

Item ID: D4334-13
Revision ID:
Item Name: Boom Block

Start Date: 7/29/2011 **Start Qty:** 1.00
Required Date: 8/2/2011 **Req'd Qty:** 1.00
Reference:

Accept

Setup **Start**
Stop

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D4334	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-8-2			
FLOW CNC Waterjet 2624 .063	1-Cut as per Dwg D necessary ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-8-2			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 Mill Conv Conventional Milling Machine	**Memo** 1-C'bore and tap as per dwg D4334	0.00 0.00	11/08/03			2			
127 QC Quality Control	~~QC5~~ QC8 - Inspect part completeness to step on W/O 11/8/2 **Memo**	0.00 0.00	11/08/03			2			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				2	0	11/08/03	

11-08-2 (2)

Picklist Print

Tuesday, August 02, 2011 10:03:37 AM

Work Order ID: 72568

Parent Item: D4334-13

Parent Item Name: Boom Block

Start Date: 7/29/2011 **Required Date:** 8/2/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP revA 11.07.28 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	34.7500	0.37	0.37			
6061-T6 Bar .500 x 6.00													

B11-8-7

Location	Loc Qty	Loc Code
MAT004	34.75	
112567	14.75	
115045	20	

112 567

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Tuesday, August 02, 2011 10:03:40 AM

Item ID: D4334-13 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Boom Block

Start Date: 7/29/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/2/2011 **Req'd Qty:** 1.00 **Customer:**

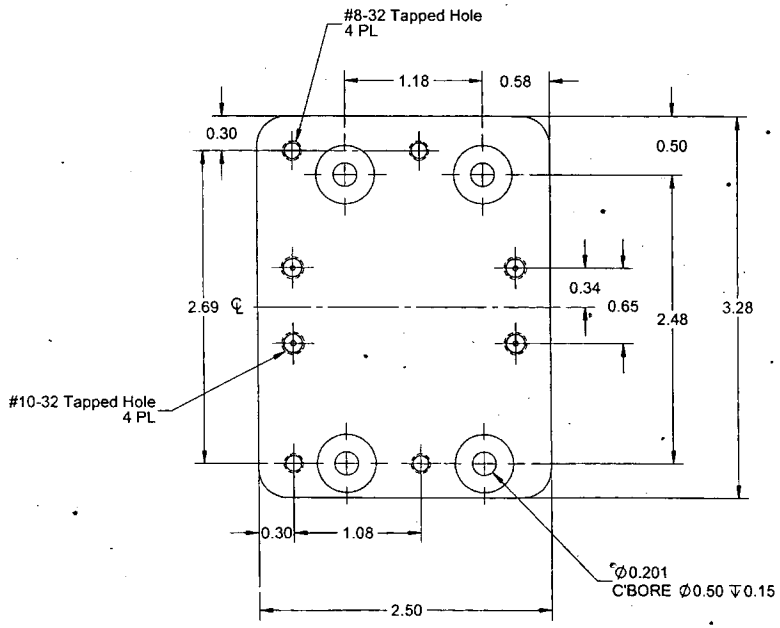
Reference:

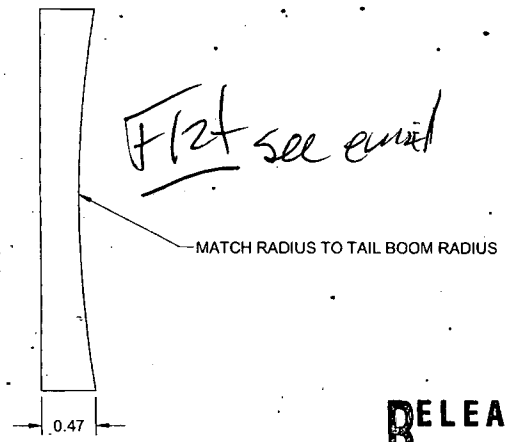
Run Start **Stop**

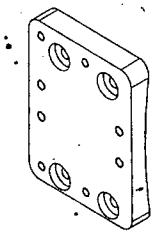
Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							2x Ø mf 11/08/03
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location:_____ SMP	0.00							
Packaging	Memo	0.00							3 ②
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							11/08/03
QC	Memo	0.00							
Quality Control									







Flat see email

RELEASED
2011 -05- 27

72568

D4334-13 BOOM BLOCK

NOTES:
1) MATERIAL: 2024-T3 OR 6061-T6 ALUMINUM SHEET 0.063 THK
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI ~~005 9.1~~
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	BC	DRAWING NO. D4334 — REV. A — SHEET 10 OF 11
MFG. APPR.	N/A	
APPROVED	N/A	TITLE: BRACKET — SCALE: NTS
DE APPR.	N/A	
DATE	11.04.18	

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Linda Lacelle

From: Jean Francois Sauve <jfsauve@dartaero.com>
Sent: August 2, 2011 9:59 AM
To: 'Linda Lacelle'
Subject: RE: Eagle Copters PO 11-002589

Yes

-----Original Message-----
From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: August 2, 2011 9:53 AM
To: 'Jean-Francois Sauve'
Subject: FW: Eagle Copters PO 11-002589

JF,
Can we make the D4334-13 flat?

LL

-----Original Message-----
From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: August 2, 2011 9:52 AM
To: llacelle@dartaero.com
Cc: Frank Mah
Subject: FW: Eagle Copters PO 11-002589

Morning Linda,

Please send the boom block flat and we will machine here. Can you give me an ETA and pricing so I can get a quote for the customer.

KL

-----Original Message-----
From: Frank Mah [mailto:fmah@eaglecopters.com]
Sent: Tuesday, August 02, 2011 7:50 AM
To: Kelly Labas
Subject: FW: Eagle Copters PO 11-002589

Hi Kelly,

Linda is waiting for your answer.

Frank

-----Original Message-----
From: Frank Mah [mailto:fmah@eaglecopters.com]

DART AEROSPACE LTD	Work Order:	72568
Description: Boom Block	Part Number:	D4334-13
Inspection Dwg: D4334-13 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	+.005 -.001	.202	✓		V B02	
.30	+/- .030	.298	✓		V	
1.18	+/- .030	1.180	✓		V	
.58	+/- .030	.580	✓		V	
.50	+/- .030	.496	✓		V	
2.48	+/- .030	2.480	✓		V	
3.28	+/- .030	3.282	✓		V	
.34	+/- .030	.34	✓		V	
.65	+/- .030	.65	✓		V	
2.50	+/- .030	2.510	✓		V	
1.09	+/- .030	1.081	✓		V	
.30	+/- .030	.30	✓		V	
2.69	+/- .030	2.688	✓		V	
~~[illegible]~~	+/- .010	~~[illegible]~~			V	
.50	+/- .030					
.50X.15	±.030	.50X.147	—		RA26	Vern
8-32	—	8X32X4	—			
10-32	—	10X32X4	—			

Measured by:	[signature]	Audited by:		Prototype Approval:	
Date:	11-8-2 11/08/03	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	